

Work Order ID 55914

February 4, 2010 11:30:23 AM



Page 1

Item ID: D2432

Accept



Setup Start



Revision ID:

Stop



Item Name: 206 (24") Bearpaw

Start Date: 2/04/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 12.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

Rev F3

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per D2432 File

m/ 10 02 08 (12)

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Inspect material for defects or damage prior to machining
2-Machine as per Folio and Dwg D2432 Identify as D2432F
3-Deburr

m/ 10/02/10

12 0

140

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

m/ 10/02/10

12 0

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Stop



Item Name: 206 (24") Bearpaw

Start Date: 2/04/10 Start Qty: 12.00



Cust Item ID:

Required Date: 2/12/10 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan: Date: Tooling: Date:

Stop



QC: Date: SPC (Y/N): Date:

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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150



QC

Quality Control

QC8- Inspect parts - second check

0.00

Memo

0.00

B.A 10/02/10

12

0

151



Packaging

Packaging

Identify as per dwg & Stock Location: PM

0.00

Memo

0.00

53074

Rec'd 12 12

190



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/02/12

W 10 02 12

Picklist Print

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Page 1

Work Order ID: 55914



Parent Item: D2432

Parent Item Name: 206 (24") Bearpaw



Start Date: 2/04/10

Required Date: 2/12/10

Comments:

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	187.8905	44.4000			
												
UHMW 1" Black												

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

156.1428

112186

122.0164

113166

34.1264

Main Warehouse

ST

31.7477

111354

31.7477

B# 113903

ml 10/02/08

DART AEROSPACE LTD		Work Order: 55114
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432 Rev: F3		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension		Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A	0.063 x 45°	+0.030/-0.010	.075x45°	✓			
B	5.500	+/-0.030	5.508	✓			
C	0.200	+/-0.030	.192	✓			
D	0.25 x 45°	+/-0.030	.247x45°	✓			
E	R0.250	+/-0.030	R.250	✓			
F	0.250	+/-0.010	.253	✓			
G	0.625	+/-0.030	.635	✓			
H	0.375	+/-0.010	.385	✓			
I	0.950	+0.030/0.010	.959	✓			
J	19.000	+/-0.030	19.006	✓			
K	3.14	+/-0.030	3.140	✓			
L	3.28	+/-0.030	3.290	✓			
M	Ø0.260	+0.005/-0.000	Ø.260	✓			
N	Ø0.93	+/-0.030	Ø.928	✓			
O	0.30	+0.030/-0.000	.302	✓			
P	23.750	+/-0.030	23.750	✓			
Q	7.375	+/-0.030	7.375	✓			
R	4.250	+/-0.010	4.250	✓			
S	2.000	+/-0.030	2.000	✓			
T	9.000	+/-0.010	9.000	✓			
U	9.000	+/-0.010	9.000	✓			
V	0.375	+/-0.010	.385	✓			

Measured by: <i>amf</i>	Audited by: <i>H.A</i>	Prototype Approval: N/A
Date: 10/02/09	Date: 10/02/10	Date:

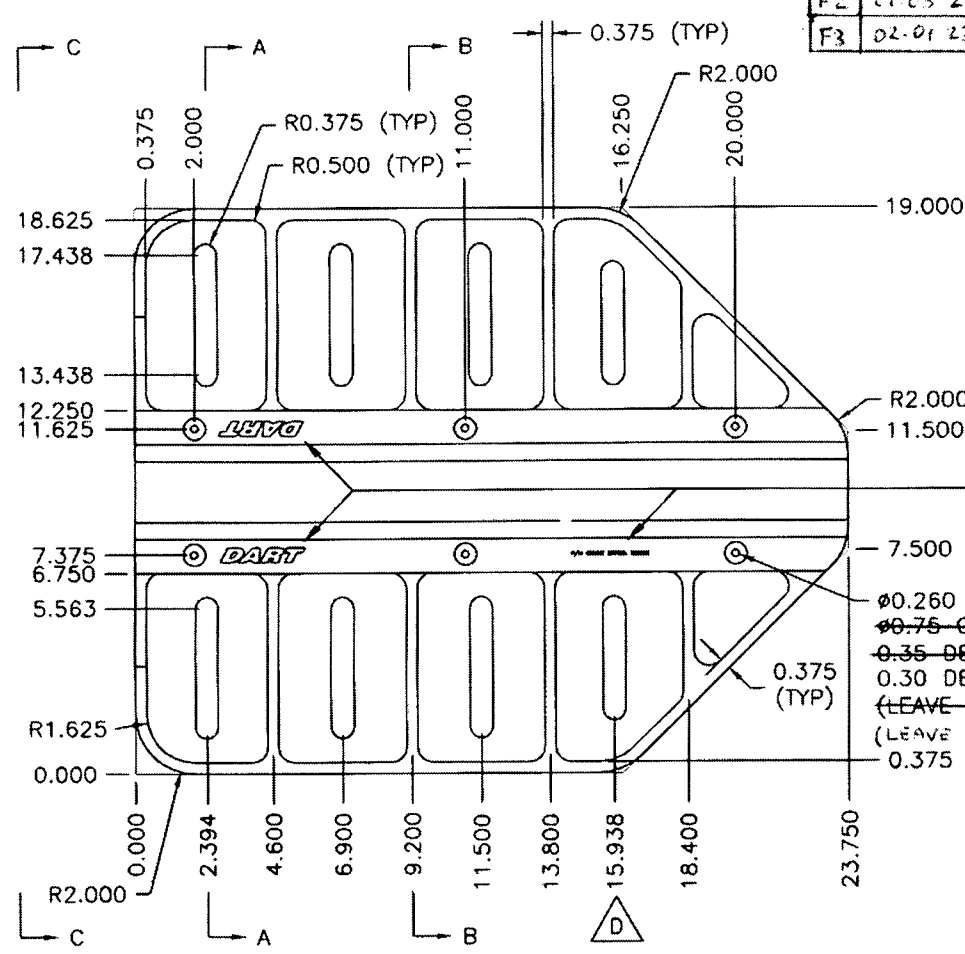
Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue	P/O K10008/D206-559-015	KJ/RF <i>[Signature]</i>

DART



RELEASED
98.06.17 K6

F1	99.03.03	ADD DEC 9143
F2	01.03.28	Ø0.75 WAS Ø0.75 RF
F3	02.01.23	CLARIFY CORE P.M.S. RF



ENGRAVE LOGO TO MAX DEPTH OF 0.012. ENGRAVE PART AND BATCH NUMBERS TO MAX DEPTH OF 0.010. (TYPICAL LOCATION AS ILLUSTRATED)

410 55914

Ø0.260 (TYP)
~~Ø0.75 C'BORE~~ Ø0.43 C'BORE
0.35 DEEP FROM TOP (MIN.)
0.30 DEEP FROM BOTTOM
(LEAVE 0.300 MIN.)
(LEAVE 0.650 MIN.)
0.375

EFFECTIVE	DEOS
9143	

D2432F: FLAT BEARPAW
D2432B: BENT BEARPAW

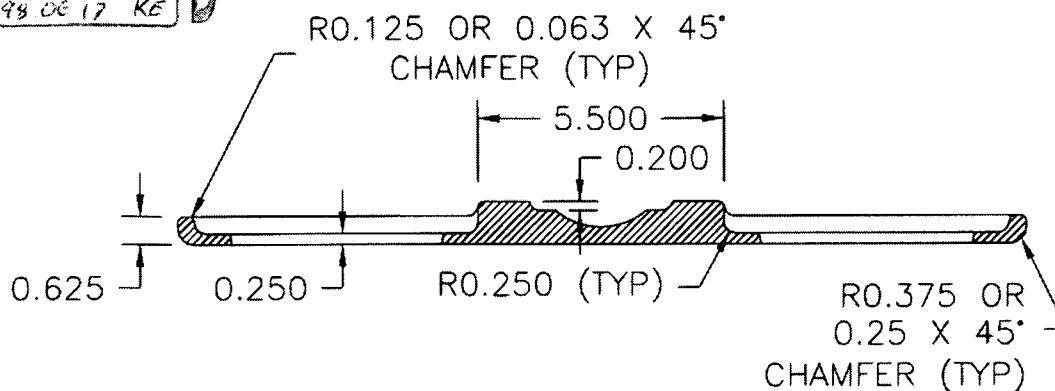
MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689
1.00 THICK (MACHINE TO 0.950)

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. F
KE	KE		
CHECKED	APPROVED	DRAWING NO.	SHEET 1 OF 2
PM		D2432	
DATE	TITLE	SCALE	
98.05.12	BEARPAW	1:6	
A	95.10.31	NEW ISSUE	
B	96.01.24	RE-DESIGN	
C	96.03.26	CHANGE BORE AND C'BORE DEPTH	
D	96.06.04	MOVE SLOT	
E	97.02.27	CHANGE C'BORE DEPTH, BORE RADIUS	
F	98.05.12	CHANGE C'BORE, ADD B AND F P/N	

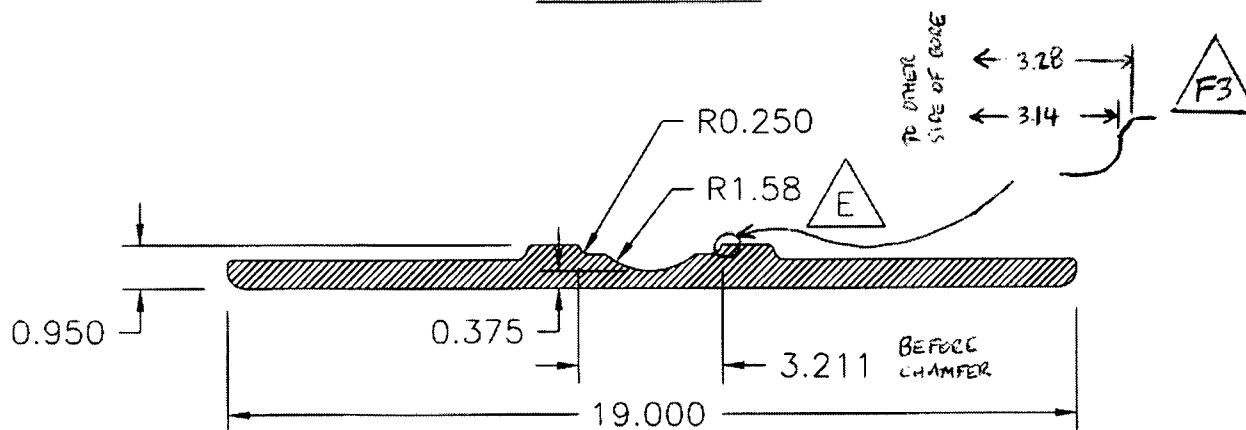


DESIGN KE	DRAWN BY KE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED P. J.	APPROVED [Signature]	DRAWING NO. D2432	REV. F SHEET 2 OF 2
DATE 98.05.12		TITLE BEARPAW	SCALE 1:4

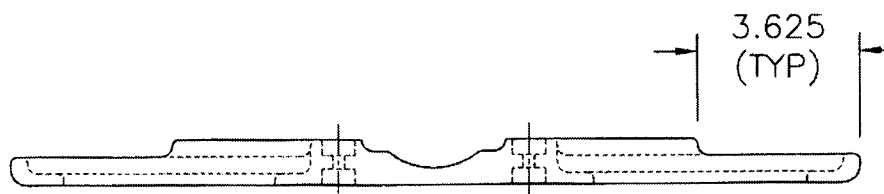
RELEASED
98 DE 17 KE



SECTION A-A



SECTION B-B



SECTION C-C